

Date: Monday, 09/03/2009 1:42:31 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : BRACKET

Job Number : 46335

Estimate Number : 10283

P.O. Number :

Part Number : D31991

This Issue : 09/03/2009 S.O. No. :

Drawing Number : D3199 REV B

Prsht Rev. : NC

Project Number : N/A

First Issue : / / Type : SMALL / MED FAB

Drawing Revision : B

Previous Run : 46252

Material :

Due Date : 20/03/2009 Qty: 40 Um: Each

Written By :

Checked & Approved By :

Comment :

: Est Rev:C Removed Scribing 05-11-05 JLM

Est Rev:D As per Rev B 06-11-24 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation:

Description :

1.0 M304S20GA

304/316 .040 Sheet



Comment: Qty.: 0.1040 sf(s)/Unit Total: 4.1580 sf(s)

304/316 0.040" SHEET

Batch: 110076

ml 09 03 11

39

2.0 WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

Cut as per Dwg D3199

Dwg Rev: B

Prog Rev: B

Deburr if required

ml 09 03 11

39

3.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 09 03 11

39

4.0 QC8

SECOND CHECK



Comment: SECOND CHECK

09-03-11 39

5.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1





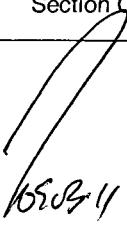
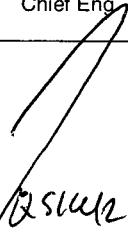
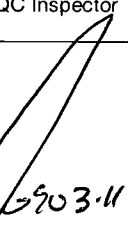
Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per dwg D3199

SP 09/03/13 39

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3199-1 PAR #: NA Fault Category: Prod / Machine Pk NCR: Yes No DQA: D Date: 8/03/20
 Resolution: SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 09/03/20

NCR: <u>46335</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/03/11	2.0	1 Scrap, chn. + tearing th edge. 2. Machine error		Destroy no replace.	 09/03/11			

NOTE: Date & initial all entries

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Drawing Name: BRACKET

Job Number: 46335

Part Number: D31991

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



09/03/13 (39)



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



M109648



Comment: POWDER COATING

POWDER COATING

Powder Coat Gey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

8:55

OVEN TEMPERATURE:

320°

FINISH TIME:

9:25

UMP/FL

09/03/17

(X39)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



918



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-03-17

(X39)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

51236A

09/03/17 (39)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



09/03/18

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 09.03.18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

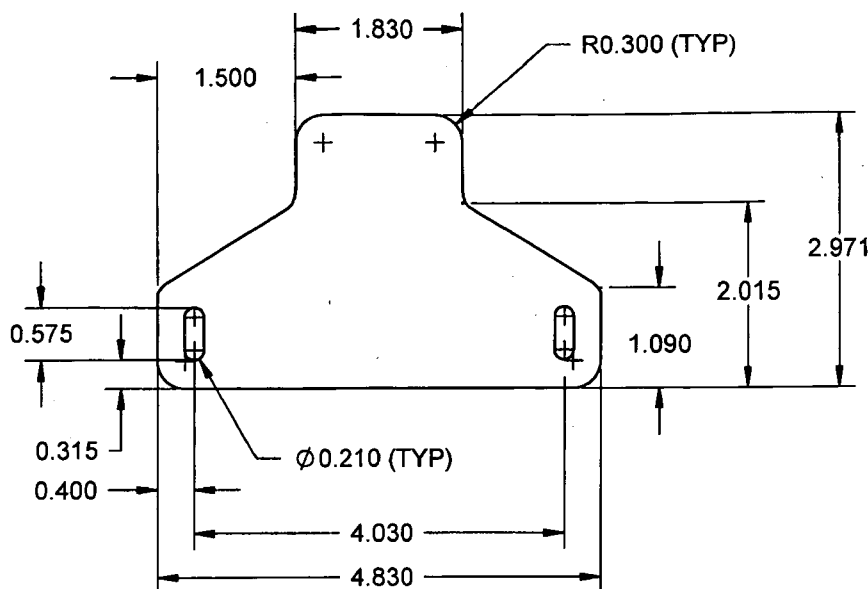
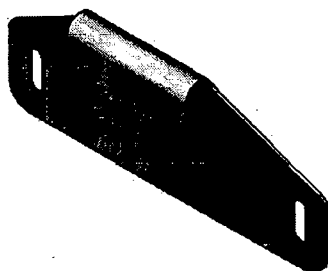
NOTE: Date & initial all entries



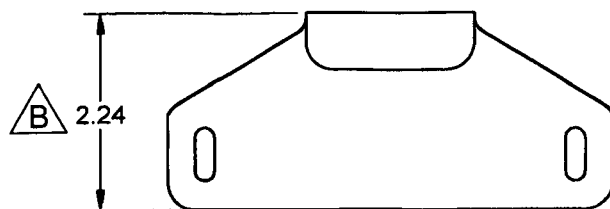
DESIGN <i>GP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3199	REV. B SHEET 1 OF 1
DATE 06.11.01		TITLE BRACKET	SCALE 1:2
REV	DATE	DESCRIPTION	
A	03.08.05	NEW ISSUE	
B	06.11.01	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	

RELEASED

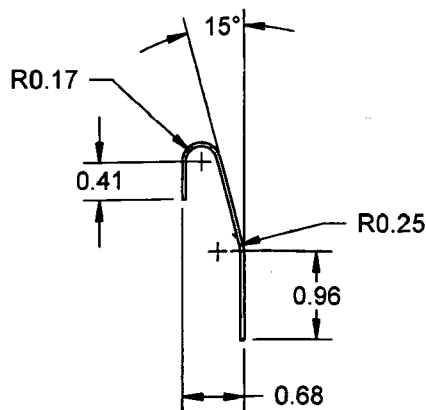
06.11.20 *[Signature]*



D3199-1 FLAT PATTERN



D3199-1 BRACKET



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET 0.040" THICK PER MIL-S-5059 (REF DART SPEC. M304S) ANNEALED COPY
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) AS PER QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) IDENTIFY WITH DART P/N "D3199-1" USING FINE POINT PERMANENT INK MARKER
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40335

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